

Date: Tuesday, 06/05/2008 8:54:08 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2891-1
Job Number : 39065	
Estimate Number : 13232	
P.O. Number :	Part Number : DSK076
This Issue : 06/05/2008 S.O. No. :	Drawing Number : DSK076 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38136	Material :
Written By :	Due Date : 23/05/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JW 08.5.06</u>	
Comment : est rev A. 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6104003

Round Billet, 17-4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Billet

Batch: 396756104-00326 08/07/23

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE

Turn blank for as per Folio FA046

26 08/07/23

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

26 08/07/23 (10)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

26 08/07/23 (10)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC26 08/07/23 (10)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/23 MF

Job Completion

MF 08-07-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39065
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278	2.278	2.278	2.278	2.278
B	3.702	3.722		3.712	3.712	3.712	3.712	3.712
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.100
F	2.464	2.484		2.474	2.475	2.475	2.474	2.475
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.975	2.975
I	0.913	0.933		.923	.924	.924	.925	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.101	.100	.100	.100	.100
L								
M								
N								
O								
P								

Measured by: [Signature]	Date: 08/07/23
Audited by: [Signature]	Date: 08/07/23
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order:	39065
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

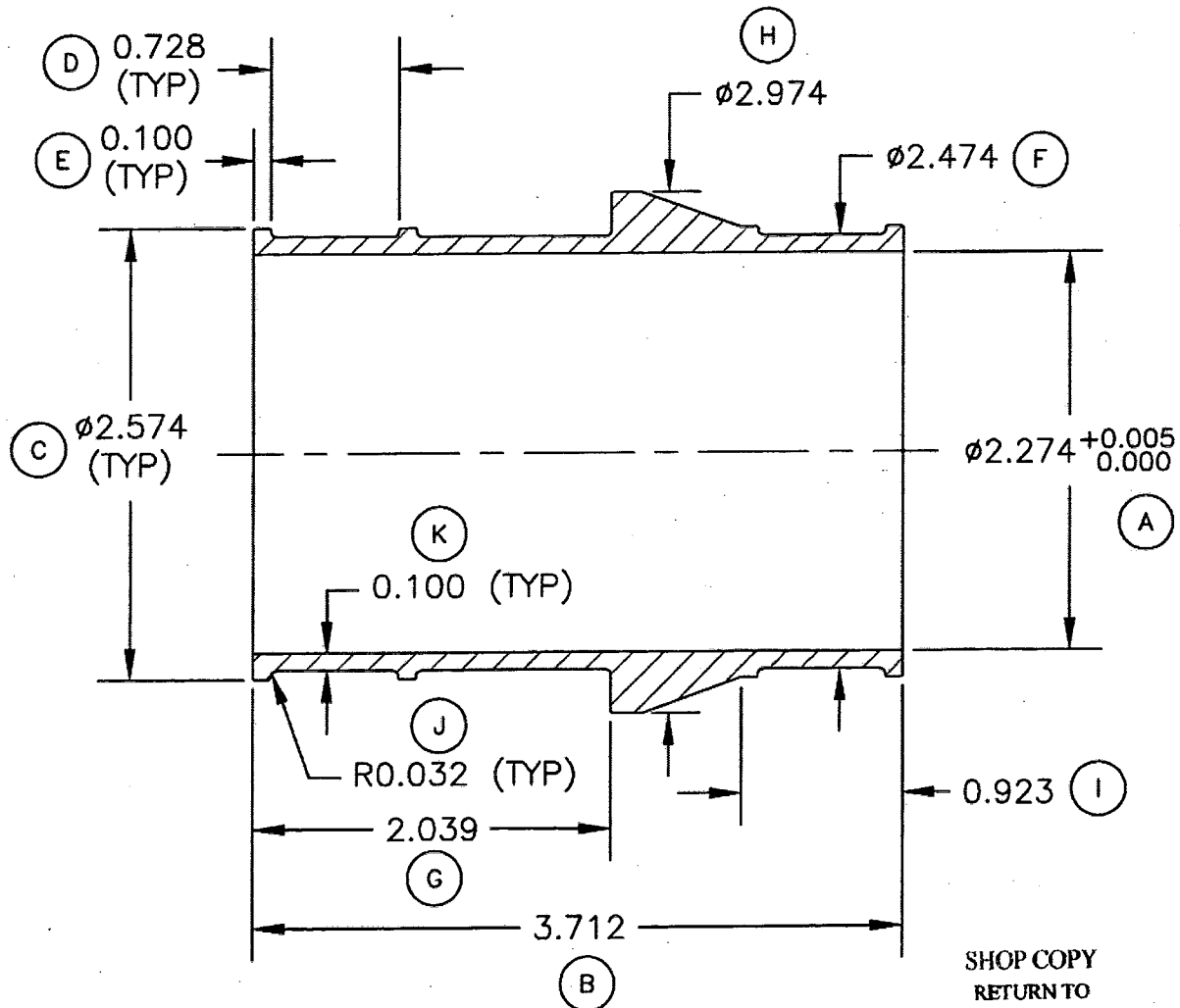
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278	2.278	2.279	2.279	2.279
B	3.702	3.722		3.712	3.713	3.713	3.712	3.715
C	2.564	2.584		2.575	2.575	2.573	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.101	.101	.102	.100
F	2.464	2.484		.474	.474	.475	.474	.475
G	2.029	2.049		2.039	2.039	2.032	2.039	2.039
H	2.964	2.984		2.975	2.975	2.974	2.974	2.975
I	0.913	0.933		.923	.925	.925	.923	.923
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.100	.100	.102	.101	.100
L								
M								
N								
O								
P								

Measured by: <i>JP</i>	Date: 08/07/23
Audited by: <i>SE</i>	Date: 08/09/23
Prototype Approval: <i>N/A</i>	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <i>AK</i>	<i>SAH</i>

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 CH**D2891-1 TURNING DETAIL**

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 391005

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